

IN THE CLAIMS

Please amend the claims as follows:

Claim 1 (Currently Amended): A gear product ~~having~~ comprising:

a plurality of ~~teeth~~ teeth formed at a predetermined pitch on an outer peripheral surface of a disc-form body thereof, wherein

a crowning is formed ~~at least~~ at ~~[[one]]~~ both end ~~[[part]]~~ parts of ~~[[a]]~~ one tooth surface of at least one gear of a plurality of gears engaging each other and one crowning is a forged crowning.

Claim 2 (Currently Amended): A gear product according to claim 1, wherein

said crowning is formed ~~at least~~ at ~~[[one]]~~ both end ~~[[part]]~~ parts of an upper side tooth surface or a lower side tooth surface of at least one ~~or the other~~ gear of the plurality of gears, and the other crowning is a cut crowning.

Claim 3 (Currently Amended): A gear product according to claim 1, wherein

said crowning is formed at two end parts ~~arbitrarily selected from four end parts of~~ ~~[[both]]~~ one of an upper side tooth surface and a lower side tooth surface of one of the gears ~~or the other gear~~ and said crowning is formed at one end of the other of said upper side tooth and said lower side tooth surface thereof.

Claim 4 (Currently Amended): A gear product according to claim 1,

wherein said crowning is formed at three end parts arbitrarily selected from four end parts of both of an upper side tooth surface and a lower side tooth surface of one of the gears ~~or the other gear.~~

Claim 5 (Currently Amended): A gear product according to claim 1, wherein
said crowning is formed at an upper end part of an upper side tooth surface of one
gear and
said crowning is formed at said upper end part and a lower end part of said upper side
tooth surface and a lower end part of a lower side tooth surface of another ~~the other~~ gear.

Claim 6 (Currently Amended): A gear product according to claim 1, wherein
said crowning is formed at upper and lower end parts of an upper side tooth surface
and an upper end part of a lower side tooth surface of one gear, and
said crowning is formed at said upper and lower end parts of said upper side tooth
surface and a lower end part of said lower side tooth surface of another ~~the other~~ gear.

Claim 7 (Currently Amended): A gear product according to claim 1, wherein
said crowning is formed at ~~an upper~~ one end part of an upper side tooth surface and a
~~lower both~~ end ~~[[part]]~~ parts of a lower side tooth surface of one gear.

Claim 8 (Currently Amended): A gear product according to claim 1, wherein
said crowning is formed at upper and lower end parts of an upper side tooth surface
and a lower end part of a lower side tooth surface of one gear and
said crowning is formed at said upper end part of said upper side tooth surface and
said lower end part of said lower side tooth surface of another ~~the other~~ gear.

Claim 9 (Currently Amended): A gear product according to claim 1, wherein
said crowning is formed at ~~a lower both~~ end ~~[[part]]~~ parts of an upper side tooth
surface and ~~an upper~~ one end part of a lower side tooth surface of one gear.

Claim 10 (Currently Amended): A gear product according to claim 1, wherein
said crowning is formed at ~~a lower~~ both end ~~[[part]]~~ parts of an upper side tooth
surface and ~~an upper~~ one end part of a lower side tooth surface of one gear and
said crowning is formed at ~~said lower~~ both end ~~[[part]]~~ parts of said upper side tooth
surface and said ~~upper~~ one end part of said lower side tooth surface of another ~~the other~~ gear.

Claim 11 (Currently Amended): A gear product having a plurality of ~~teeth~~ teeth
formed at a predetermined pitch on an outer peripheral surface of a disc-form body thereof,
wherein
tooth forms of all teeth are unified to one pattern selected from a plurality of patterns
in which a crowning is formed at at least one of four parts of ~~every~~ both ends on each tooth
surface of said teeth, and said crowning is not formed at ~~the other~~ one part of said four parts
thereof.

Claim 12 (Currently Amended): A gear product according to claim 11, wherein
said selected pattern is one of ~~fourteen~~ six patterns comprising ~~four patterns in which~~
~~said crowning is formed at one of an upper end part or lower end part of an upper inclined~~
~~surface, and an upper end part or a lower end part of a lower inclined surface,~~

~~[[six]]~~ two patterns in which said crownings are formed at two parts such as said
upper end part and said lower end part of said upper inclined surface, ~~said upper end part of~~
~~said upper inclined surface and said upper end part of said lower inclined surface, said upper~~
~~end part of said upper inclined surface and said lower end part of said lower inclined surface,~~
~~said lower end part of said upper inclined surface and said upper end part of said lower~~
~~inclined surface, said lower end part of said upper inclined surface and said lower end part of~~

~~said lower inclined surface~~, or said upper end part and lower end part of said lower inclined surface, and

four patterns in which said crownings are formed at three parts such as said upper end part and said lower end part of said upper inclined surface and said upper end part of said lower inclined surface, said upper end part and said lower end part of said upper inclined surface and said lower end part of said lower inclined surface, said upper end part of said upper inclined surface and said upper end part and said lower end part of said lower inclined surface, or said lower end part of said upper inclined surface and said upper end part and said lower end part of said lower inclined surface.

Claim 13 (Currently Amended): A gear product according to claim 1 ~~any one of claims 1-12~~, wherein

said plurality of teeth ~~teeth~~ formed on said outer peripheral surface of said disc-form part thereof are ~~is~~ a helical teeth ~~teeth~~.

Claim 14 (Currently Amended): A method for manufacturing a gear product having a plurality of teeth ~~teeth~~ formed at a predetermined pitch on an outer peripheral surface of a disc-form body thereof, wherein

a crowning is formed at least at one end part of a tooth surface of at least one gear of a plurality of gears engaging each other, wherein

a tooth form having said crowning of a tooth formed on said outer peripheral surface, is formed by cutting and forging.

Claim 15 (Cancelled)

Claim 16 (Original): A method for manufacturing a gear product according to claim 14, wherein

a tooth form having said crowning of a helical tooth formed on said outer peripheral surface is formed by upsetting on forging.

Claim 17 (Original): A method for manufacturing a gear product according to claim 14, wherein

a tooth form having said crowning of a helical tooth formed on said outer peripheral surface is formed by ironing on forging.

Claim 18 (Currently Amended): A method for manufacturing a gear product, wherein

a first molding having a plurality of teeth ~~teeth~~, having no crowning, formed at a predetermined pitch on an outer peripheral surface of a disc-form body thereof is cut and forged so that tooth forms of all teeth may be unified to a pattern selected from a plurality of patterns in which said crowning is formed at at least one of four parts of ~~every~~ both ends on each tooth surface of said teeth and said crowning is not formed at ~~the other~~ one part of said four parts thereof.

Claim 19 (Currently Amended): A method for manufacturing a gear product, wherein

a first molding having a plurality of helical teeth ~~teeth~~, having no crowning, formed at a predetermined pitch on an outer peripheral surface of a disc-form body thereof is molded by upsetting so that said crowning can be formed at an upper part of an upper side tooth surface

and a lower part of a lower side tooth surface among four parts of both ends parts of tooth surfaces of said all teeth.

Claim 20 (Currently Amended): A method for manufacturing a gear product,
wherein

a first molding having a plurality of helical ~~teeth~~ teeth, having no crowning, formed at a predetermined pitch on an outer peripheral surface of a disc-form body thereof is molded by ironing so that said crowning may be formed at a lower part of an upper side tooth surface and an upper part of a lower side tooth surface among four parts of both end parts of tooth surfaces of said all teeth.